

Date: Thursday, 2/9/2006 1:46:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG AND BRACKET
Job Number : 25762	
Estimate Number : 11127	
P.O. Number : N/A	Part Number : D301615
This Issue : 2/9/2006 S.O. No. : N/A	Drawing Number : D3016 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/15/2006 Qty: 10 Um: Each
Checked & Approved By : JF 06.02.10	
Comment : Est. B 03.05.09 Reformat KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 0.0510 sf(s)/Unit Total : 0.5103 sf(s)
 4130 Sheet .049 wall
 Material: AISI 4130N Sheet, 0.049" thick
 (M4130N-S049)
 Identify for D3016-15
 Batch: M9319

J.F. 06/02/26 16

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 2.580" x 2.580" (+0.010/-0.000)

J.F. 06/02/26 16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3016-15 as per Folio FA162 and Dwg D3016
 Use Stack of 8
 Identify as D3016-15

J.F. 06/02/26 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/02/26 16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 06.02.26 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG AND BRACKET

Job Number: 25762

Part Number: D301615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RC

06.02.26

16

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and bag with light oil (Vactra oil #2), then Stock

Location: _____

DAVID S. SUTHER

RC

06/2/27

16

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RC

06/02/27

(16)

Job Completion



U

06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

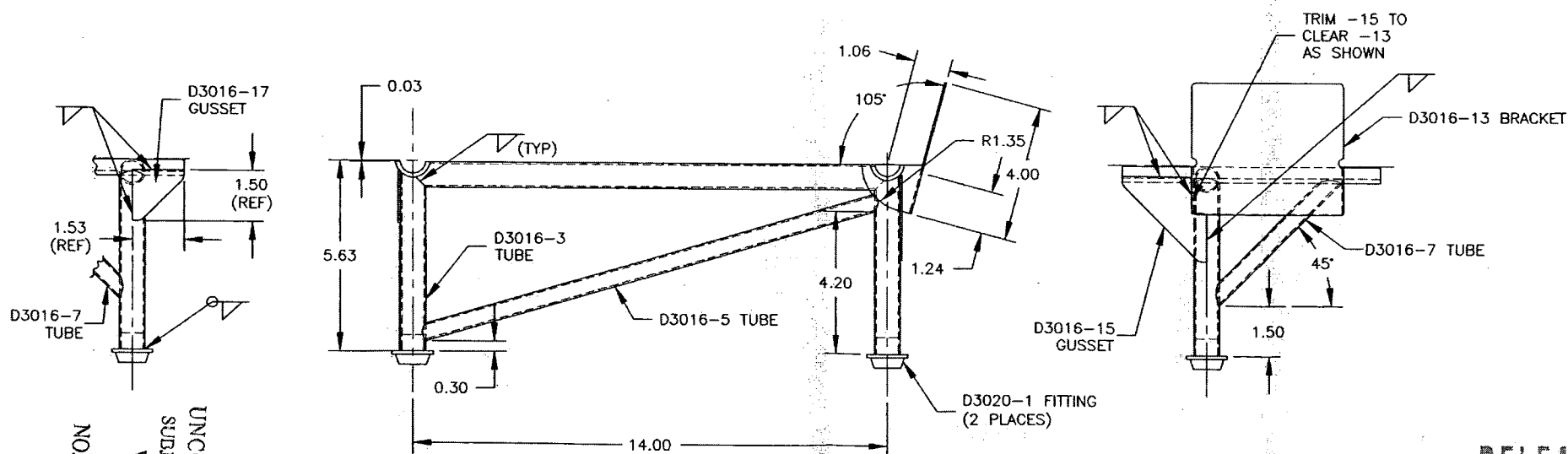
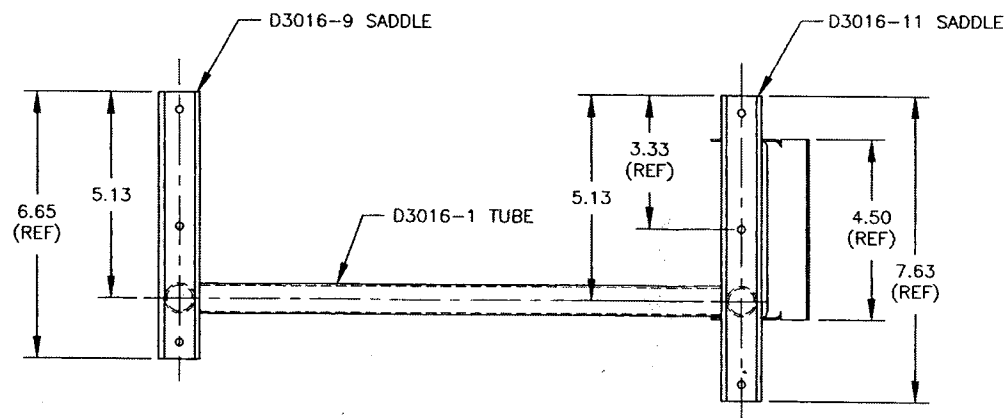
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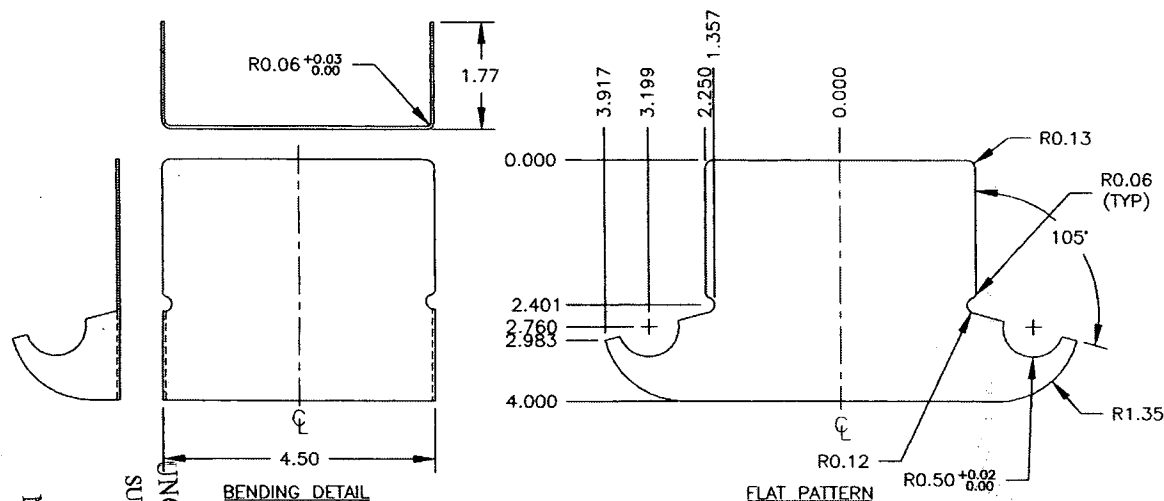
D3016-041 SEAT FRAME ASSEMBLY



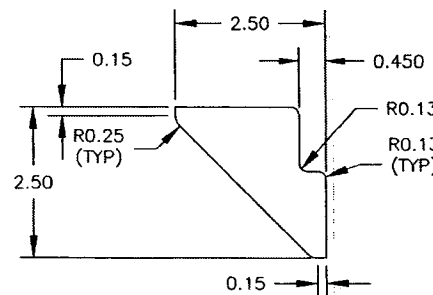
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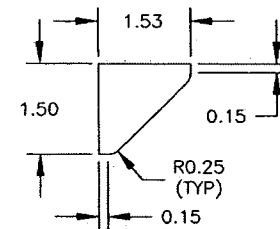
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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:3	



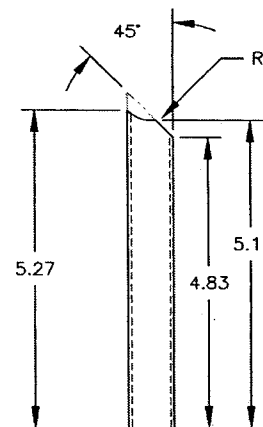
D3016-13 BRACKET



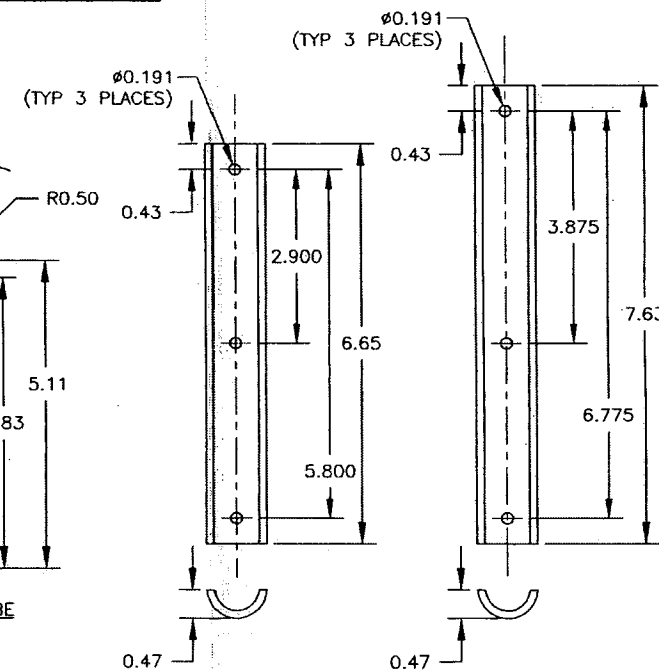
D3016-15 GUSSET



D3016-17 GUSSET



D3016-3 TUBE

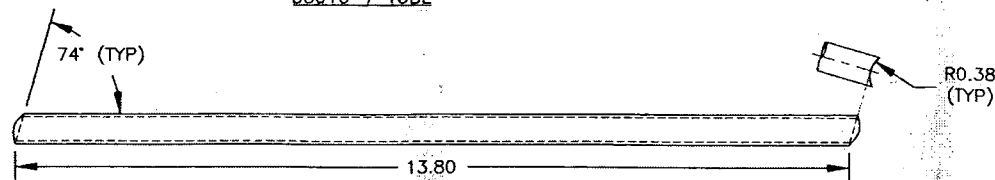


D3016-9 SADDLE

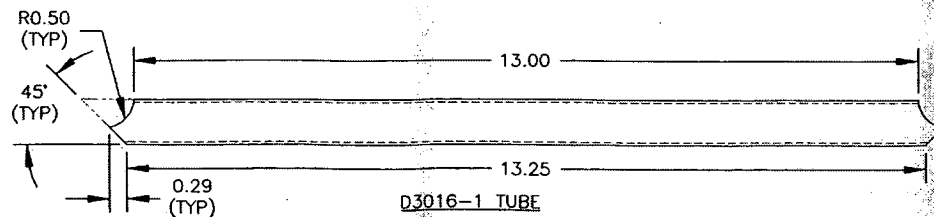
D3016-11 SADDLE

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D3016-5 TUBE



D3016-1 TUBE

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DESIGN	UP	DRAWN BY	UP	DART	DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:2

- 5/04

DART AEROSPACE LTD	Work Order:	22066
Description: Lug and Bracket	Part Number:	D3016-13/-15/-17
		D3017-7
Dwg: D3016 Rev. A; D3017 Rev. A page 1	Qty:	20 Kits
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler To be made in multiples of 8.	<i>HA</i>	04.12.08	2
2	MV	Cut blanks: 1.53" x 1.50" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-17			
		Batch: <i>M16443 CPL 05-01-08 20</i>			
3	MV	Cut blanks: 7.90" x 4.070" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-13			
		Batch: <i>N/A</i>			
4	MV	Cut blanks: 2.580" x 2.580" (+0.010/-0.000) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3016-15			
		Batch: <i>N/A</i>			
5	MV	Cut (12) D3017-7 blanks per 8 Kits Cut blanks: 4.200" x 3.180" (+/-0.010) Material: AISI 4130N Sheet, 0.049" thick (M4130N-S049) Identify for D3017-7			
		Batch: <i>N/A</i>			
6	MV	Machine D3016-15 as per Folio FA162 and Dwg D3016 Use Stack of 8 Identify as D3016-15			
			<i>N/A</i>		
7	QC2	Inspect parts as they come off the CNC machine			
8	MV	Deburr			
9	QC5	Second check			
10	MV	Machine D3016-13 as per Folio FA162 and Dwg D3016 Use Stack of 8 Identify as D3016-13			
11	QC2	Inspect parts as they come off the CNC machine			
12	MV	Deburr			
13	QC5	Second check			
14	MV	Machine D3017-7 as per Folio FA163 and Dwg D3017 Use Stack of 6 Identify as D3017-7			
			<i>N/A</i>		
15	QC2	Inspect parts as they come off the CNC machine			
16	MV	Deburr			
17	QC5	Second check			
18	GA	Grind D3016-17 radius as per Dwg D3016 Identify as D3016-17	<i>2</i>	05-03-01	20
19	GA	Deburr	<i>2</i>	05-03-01	20

DART AEROSPACE LTD	Work Order:	22066
Description: Lug and Bracket	Part Number:	D3016-13/-15/-17
Dwg: D3016 Rev. A; D3017 Rev. A page 1	Qty:	D3017-7 2 Kits
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	QC5	Inspect work to Step 19			
21	GB	Form D3017-7 as per Dwg D3017 and D3016-13 as per Dwg D3016			
22	QC5	Inspect work to Step 21			
23	GA	Identify and bag with light oil (Vactra oil No. 2) D3016-13 Qty: <u>20</u> D3016-15 Qty: <u>20</u> D3016-17 Qty: <u>20</u> D3017 Qty: <u>20</u>		05/03/01	20
24	AC	Parts to Stock and prorate cost of parts per Step 23 Cost / part <u>1.82</u>	S45	05.03.01	20
25	DC	Close W/O <u>1.82</u> Inspect Level 21		05.03.02	20

Rev	Date	Change	Revised By	Approved
A	01.09.11	New issue	EC	
B	03.05.09	Reformat	KJ/RF	

RELEASED
03.06.11 RF